

**THERMAL ARC**  
*Professional* 

**Durable,  
Powerful &  
Dependable**



**UltraFeed® Range**





## ***Thermal Arc Professional: when welding is your business***

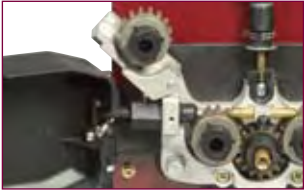
Thermal Arc is on the move! The Thermal Arc family of arc welding equipment has been completely overhauled, re-engineered and expanded following extensive research and development activities. We have rebuilt our range to ensure products meet your requirements and expectations for outstanding performance, durability and dependability.

Quality, reliability and after sales back-up are the three key attributes for every product while at the same time delivering a cost competitive solution for our customers.

Our Ultrafeed range is proof of this commitment to delivering quality equipment that does the job and where necessary exceeds expectations! A wealth of features, options and compatibility with other equipment make Thermal Arc Ultrafeed wirefeeders the perfect choice for the serious welding professional.



## The Thermal Arc Ultrafeed® Range:



- Heavy duty pressure arms and drive system



- Standard TWECO® No. 4 welding gun quick disconnect



- Wire spool hub with locking assembly

The Thermal Arc Ultrafeed® Series of wire feeders are built for the toughest industrial welding applications. Designed to run with CV arc welding power sources with 115 VAC auxiliary power, these workhorses meet the match for most industrial semi-automatic wire welding applications.

Standard features on all units include:

- Control cable and drive rolls
- Enlarged rubberized control knobs
- Inch and purge switches
- Robust heavy duty rear spool mounting designed for spools and coils
- Heavy duty base with no slip feet
- Standard Tweco® No. 4 welding gun quick disconnect
- Wire spool hub with locking assembly
- Machined feedhead and tension arms
- Geared top and bottom drive rolls
- Quick change drive rolls
- Gas valve and solenoid
- Common drive rolls for all models
- Common options and accessories

All these features combined with the robust design delivers a range of wire feeders that are ideal for the welding professional.



## Ultrafeed A 2000

*maximum value, lightweight & reliable*

### Machine Specifications

Input Voltage	115 VAC
Input Frequency	50 / 60 Hz
Input Voltage Tolerance	± 10%
Maximum Input Current	1.5 Amps
Wire Speed Range (For all filler wire sizes)	30-650 IPM (.76-16.6 m/min.)
Wire Size Range	0.024" - 5/64" (0.6 - 2.0 mm)
Maximum Spool Size	60 lb. (27.3kg)
Feed Rolls	2 gear driven
Welding Current	450A at 100% Duty Cycle
Welding Gun Inlet Size (std.)	5/8" (15.9mm) nominal, Tweco® #4
Maximum Shielding Gas Inlet Pressure	100 psi (689 Kpa)
Dimensions (HxWxD)	10.3"x12.4"x19" (262x315x483mm)
Weight	30 lbs. (13.6 kg)
Approvals	IEC 60974-1(CE), NEMA EW-3



The Thermal Arc Ultrafeed® A 2000 wire feeder is built for the toughest industrial welding applications. Designed to run with CV arc welding power sources with 115VAC auxiliary power, this 2 roll workhorse will perform with wire sizes .024" -5/64" (0.6-2.0mm) on most industrial semi-automatic wire welding applications. The Ultrafeed® A 2000 offers excellent value with its variac control design, ensuring improved reliability, lowering operating and repair costs.

Standard features include:

- Control cable and drive rolls
- Electro-mechanical brake
- Circuit breaker
- Enlarged rubberized control knob
- Inch and purge switches
- Robust heavy duty rear spool mounting designed for spools and coils
- Heavy duty base with no slip feet
- Standard Tweco® No 4 welding gun quick disconnect
- Wire spool hub with locking assembly
- Machined feedhead and tension arm
- Geared top and bottom drive rolls
- Quick change drive rolls
- Gas solenoid valve



\* Limited warranty. Refer to warranty schedule.



## Ultrafeed VA 2000 feature loaded, lightweight & reliable

### Machine Specifications

Input Voltage	115 VAC
Input Frequency	50 / 60 Hz
Input Voltage Tolerance	± 10%
Maximum Input Current	4 Amps
Wire Speed Range (For all filler wire sizes)	70-660 IPM (1.8-16.8 m/min.)
Wire Size Range	0.024" - 5/64" (0.6 - 2.0 mm)
Maximum Spool Size	60 lb. (27.3kg)
Feed Rolls	2 gear driven
Welding Current	425A at 100% Duty Cycle
Welding Gun Inlet Size (std.)	5/8" (15.9mm) nominal, Tweco® #4
Maximum Shielding Gas Inlet Pressure	100 psi (689 Kpa)
Dimensions (HxWxD)	10.3"x12.4"x19" (262x315x483mm)
Weight	32 lbs. (14.5 kg)
Approvals	IEC 60974-1(CE), NEMA EW-3

The Thermal Arc Ultrafeed® VA 2000 wire feeder is built for the toughest industrial welding applications. Designed to run with CV arc welding power sources with 115 VAC auxiliary power, this 2 roll workhorse will perform with wire sizes .024" - 5/64" (0.6- 2.0mm) on most industrial semi-automatic wire welding applications. The Ultrafeed® VA 2000 features remote voltage control, digital meter, gun trigger hold (2T/4T) and a "unique" feed monitor display for preventative maintenance.

Standard features include:

- Control cable and drive rolls
- Remote voltage control
- Digital meter
- Unique feed monitor display
- Gun trigger hold (2T/4T)
- Run-in time adjuster
- Electronic speed control and brake
- Ground fault, motor and contactor protection
- Enlarged rubberized control knob
- Inch and purge switches
- Robust heavy duty rear spool mounting designed for spools and coils
- Heavy duty base with no slip feet
- Standard Tweco® No 4 welding gun quick disconnect
- Wire spool hub with locking assembly
- Machined feedhead and tension arm
- Geared top and bottom drive rolls
- Quick change drive rolls
- Gas solenoid valve



## Ultrafeed VA 4000

*feature loaded, heavy duty and durable*

### Machine Specifications

Input Voltage	115 VAC
Input Frequency	50 / 60 Hz
Input Voltage Tolerance	± 10%
Maximum Input Current	4 Amps
Wire Speed Range (For all filler wire sizes)	50-875 IPM (1.25-22.1 m/min.)
Wire Size Range	0.024" - 1/8" (0.6 - 3.2 mm)
Maximum Spool Size	60 lb. (27.3kg)
Feed Rolls	4 gear driven
Welding Current	500A at 100% Duty Cycle
Welding Gun Inlet Size (std.)	5/8" (15.9mm) nominal, Tweco® #4
Maximum Shielding Gas Inlet Pressure	100 psi (689 Kpa)
Dimensions (HxWxD)	12.2"x13.2"x20.2" (310x335x513mm)
Weight	41 lbs. (18.5 kg)
Approvals	IEC 60974-1(CE), NEMA EW-3

The Thermal Arc Ultrafeed® VA 4000 wire feeder is built for the toughest industrial welding applications. Designed to run with CV arc welding power sources with 115 VAC auxiliary power, this 4 roll workhorse will perform with wire sizes .024" - 1/8" (0.6- 3.2mm) on most industrial semi-automatic wire welding applications. The single feed head Ultrafeed® VA 4000 features remote voltage control, digital meter, preflow, postflow, burnback and spot timer, gun trigger hold (2T/4T) and a 'unique' feed monitor display for preventative maintenance. The VA 4000 will meet the match for the professional welder

Standard features include:

- Control cable and drive rolls
- Run-in time adjuster
- Electronic speed control and brake
- Ground fault, and electronic motor protection
- Enlarged rubberized control knob
- Inch and purge switches
- Robust heavy duty rear spool and coil mounting
- Heavy duty base with no slip feet
- Standard Tweco® No 4 welding gun quick disconnect
- Wire spool hub with locking assembly
- Machined feedhead and tension arm
- Geared top and bottom drive rolls
- Quick change drive rolls
- Gas solenoid valve



- Shown with optional lifting eye kit

\* Limited warranty. Refer to warranty schedule.

## Ultrafeed VA 4000D dual feed head top of the range, heavy duty & durable

### Machine Specifications

Input Voltage	115 VAC
Input Frequency	50 / 60 Hz
Input Voltage Tolerance	± 10%
Maximum Input Current	4 Amps
Wire Speed Range (For all filler wire sizes)	50-875 IPM (1.25-22.1 m/min.)
Wire Size Range	0.024" - 1/8" (0.6 - 3.2 mm)
Maximum Spool Size	60 lb. (27.3kg)
Feed Rolls	4 gear driven (2 sets)
Welding Current	500A at 100% Duty Cycle
Welding Gun Inlet Size (std.)	5/8" (15.9mm) nominal, Tweco® #4
Maximum Shielding Gas Inlet Pressure	100 psi (689 Kpa)
Dimensions (HxWxD)	13.5"x18.5"x26.5" (343x470x673mm)
Weight	79 lbs. (35.9 kg)
Approvals	IEC 60974-1(CE), NEMA EW-3

The Thermal Arc Ultrafeed® VA 4000D wire feeder is built for the toughest industrial welding applications. Designed to run with CV arc welding power sources with 115 VAC auxiliary power, this 4 roll workhorse will perform with wire sizes .024" - 1/8" (0.6- 3.2mm) on most industrial semi-automatic wire welding applications. The dual feed head Ultrafeed® VA 4000D features remote voltage control, digital meter, preflow, postflow, burnback and spot timer, gun trigger hold (2T/4T) and a 'unique' feed monitor display for preventative maintenance. The VA 4000D will meet the match for the professional welder

Standard features include:

- Control cable and drive rolls
- Run-in time adjuster
- Electronic speed control and brake
- Ground fault, and electronic motor protection
- Enlarged rubberized control knob
- Inch and purge switches
- Robust heavy duty rear spool and coil mounting
- Heavy duty base with no slip feet
- Standard Tweco® No 4 welding gun quick disconnect
- Wire spool hub with locking assembly
- Machined feedhead and tension arm
- Geared top and bottom drive rolls
- Quick change drive rolls
- Gas solenoid valve



\* Limited warranty. Refer to warranty schedule.



## ***The Ultrafeed® Series: Versatile work partners***

The Ultrafeed VA 4000 Series wire feeders are versatile additions to your equipment range. They are fully compatible with most Thermal Arc® CV or CC/CV power sources with a 19 pin amphenol connector.

Another exciting new feature on the VA 2000 and 4000's is the integrated Feed Monitor Display. This has been designed to alert the user to potential feeding problems. Through a LED bar graph indicator on the front of the wire feeder, information on the stability and consistency of wire feeding is relayed to the user to assist in determining when it is time to replace tips, liners, wire guides, or drive rolls. As these items become dirty or worn due to normal operating conditions, the user will see an increase in the number of lit LED's on the feed monitor display.

Optional kits that can be added to the VA 4000's include a Dual Schedule Kit and Advanced Interface Kit. The dual schedule kit provides you with the option of a second schedule for wire speed and voltage. The advanced interface kit is for the set-up of automated processes. Through the 19 pin connector, features available include, stop/start, schedule select, inch/purge inputs; arc, standby and fault outputs; 0-10 VDC analog inputs for wire speed and voltage control; as well as a RS 232 Serial port for communication to a PC and a CAN port for communication with other select Thermal Arc® power sources.



- Unique feed monitor display for preventative maintenance



- Large digital meters displaying, wire speed or voltage



- Lifting eye

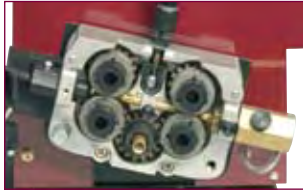




## *The Ultrafeed® Series: feedhead assembly with adjustable rotating feedhead*



• Calibrated tension knob



• Heavy duty pressure arms and drive system

Both the Ultrafeed® VA 4000 and VA 4000D feature rotating feedheads that allow the feedhead angle to be changed to optimize wire feedability, as well as precision machined, heavy duty tension arms that ensure wire alignment tolerances of  $\pm .002"$ . Both top and bottom drive rolls on the Ultrafeed® range are geared to maximize wire traction with the added drive roll quick change option without the need for tools. They have as standard the Tweco® No: 4 welding gun quick disconnect feature, heavy brass electrical welding gun tail stock connections and fully molded spring loaded polypropylene feedhead cover to ensure stay open, stay closed operation.



Adjustable rotating feedhead feature is only available on Ultrafeed® VA 4000 and VA 4000D

## Ordering details



Product	Part No.	Description
Ultrafeed® A 2000	W3200001	Wire feed speed/amp control, 2 roll
Ultrafeed® VA 2000	W3300001	Wire feed speed & remote voltage control, 2 roll
Ultrafeed® VA 4000	W3400001	Wire feed speed & remote voltage control, 4 roll
Ultrafeed® VA 4000D	W3420001	Dual feed head, wire feed speed & remote voltage control, 4 roll
<b>KITS</b>		
Ground Fault Interrupt Kit	8709081	
Preflow, Postflow, Spot Timer Kit	171462	
Dual Schedule Kit	W4008001	Provides a second schedule for wire feed speed and voltage
Advanced Interface Kit	870379	19 pin plug; start/stop; schedule select; inch & purge inputs; arc standby & fault outputs; 0-10VDC analog input
<b>ACCESSORIES</b>		
Drive Roll Kits	375980-XXX	A kit (two with dual) is supplied standard with each wire feeder, see drive roll kit chart to select a different drive roll style
Control Cable		Control cable from wire feeder to power source (A 6ft. control cable #374878-006 is supplied with the wire feeder)
6 ft (1.8m)	374878-006	
15ft (4.5m)	374878-015	
25ft (7.6m)	374878-025	
50ft (15.2m)	374878-050	
100ft (30.5m)	374878-100	
Interconnect Cable Assembly		Complete interconnect assembly from wire feeder to power source, inc. control cable, welding power cable and gas hose in a sheathed cover.
6 ft (1.8m)	W4009200	
15ft (4.5m)	W4009201	
25ft (7.6m)	W4009202	
50ft (15.2m)	W4009203	
Wire Spool Adapter		
10 lb (4.5kg), 8" spool	375585-001	
15 lb (6.8kg), 8" spool	375864-001	
Spool Cover		
30 lb (13.6kg) spool	375582A-004	
60 lb (27.2kg) spool	375733A-001	
Wire Reel Kit	870059	
Wire Coil Adapter		
14 lb (6.4kg) coil	375942A	
60 lb (27.3kg) coil	407142A	
Wire Feeder Cart	W4000001	
Lifting Eye Kit	W4002001	Electrically isolated
MIG Gun Adapter Kits		
Tweco® #5	870395	
Miller®	870397	
Euro-style	171449	
Cable Adapters		
19 pin wire feeder to 5 pin power source	870000-001	For older style power sources
19 pin wire feeder to 14 pin power source	870093B-001	For Miller® or 14 pin style power sources
<b>POWER SOURCES</b>		See corresponding literature
ArcMaster® 300MST, 400MST, 400MSTP		
PowerMaster® Series		
Excel-Arc® Series		
Fabstar® 4030		
Fabstar® 4030		When connected to Fabstar® 4030 actual arc amps on wire feeder will not show and preset volts on power source will not be displayed







**Customer Care USA** Tel: 800 255 5846 Fax: 800 332 0946

**Thermadyne Canada** Tel: 905 827 1111 Fax: 905 827 0813

**International Customer Care** Tel: 905 827 9777 Fax: 905 827 9797

**[www.thermalarc.com](http://www.thermalarc.com)**

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FORM NO. 84-2601

